

Work Order ID 54193

December 2, 2009 11:41:17 AM



Page 1

Item ID: D350-591-214

Accept



Setup Start



Revision ID: A

Stop



Item Name: Heli-Access-Step, Short RH

Start Date: 02/12/2009 Start Qty: 4.00



Cust Item ID:

Required Date: 16/12/2009 Req'd Qty: 4.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

[Signature]

Date: 09/12/2

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
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D3078	A
-------	---

DSI 9472	A
----------	---

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile and type labels as per PPP D350-591-214 CHG003

8 21/12/17

100 for BG 09/12/17

110

0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

1-Cut D2622-120 extrusion to 59.75" long as per Dwg D3078
2-Drill extrusion as per Dwg D3078 using Jig DT8680 for rivets.
3-Deburr

1609-12-08

4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 27 8 01/12/09 0.00							
130 Large Fab Large Fab	Large Fab Memo 1-Bevel end for welding FWD ONLY 2-Weld Support using Jig DT8681, weld Fwd End Plate as per QSI 004 & Dwg D3078 A/RA Aluminum Rod 27/11/3/1 3-Grind End Plate flush 27/11/4/4	0.00 0.00				4	0		BE 09/12/09
140 QC Quality Control	QC9- Inspect visual per QSI004- Fusion Welds Memo	0.00 0.00							

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150 QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00	2) 8 09/12/09			4 PH			
160 HandFinish Hand Finishing	Chemical Conversion Coat per QS1005 4.1 Memo	0.00 0.00	12 09.12.14			4			
170 QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00	SP 09/12/14			4			

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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
200		0.00							
	Large Fab					4	0		
Large Fab	Memo	0.00							
Large Fab	1- Rivet Leg Assembly as per Dwg D3078.								
	2-Bevel Aft end for welding								
	3-Inspect for foreign object as per QSI 024								
	4-Weld Aft End Plate as per QSI 004 & Dwg D3078								
	A/R Aluminum Rod								
	5-Grind End Plate flush								
210	QC9- Inspect visual per QSI004- Fusion Welds	0.00							
QC	Memo	0.00							
Quality Control									

09.12.15

09.12.15

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
220 QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00	27	8	09/12/15	4 RH			
230 HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00	16	09-12-15		4 RH			
240 Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum Memo START TIME: 9:15 OVEN TEMPERATURE: 320° FINISH TIME: 9:45	0.00 0.00	11	13	170 09-12-16	4 RH			

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Stop



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250

Wing Walk as per dwg QSI005 4.4 Batch M112638

JH 09/12/16



HandFinish

Memo

0.00

Hand Finishing

X4RH

8

260

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

27 Serial 1217

27

RH

270

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

9/12/16 sl 4

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Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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280

QC4- 100% Inspect kits for completeness

0.00



27 Dec 12/17

QC

Memo

0.00

Quality Control

14
RH

290

Packaging

0.00



Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP D350-591-214

Location: _____

PPP Rev: _____

09/12/18 14

300

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/12/21
RH 09/12/18
(4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

December 2, 2009 11:41:26 AM

Page 1

Work Order ID: 54193

Parent Item: D350-591-214RevA

Parent Item Name: Heli-Access-Step, Short RH

Comments: IPP Rev:D 06-06-27 Revised as per DSI9340 JLM
Ipp Rev E 09.11.23 added comment for D2732 EC

Start Date: 02/12/2009

Required Date: 16/12/2009

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3065-041RevB		Manufactured	No				Each	48.0000	4.0000			
Step Leg Assembly Hi												

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

32

53523

32

Main Warehouse

WA

16

52104

16

Each

158.0000 8.0000

D3066-1RevB

Manufactured No



Spacer

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

158

51545

11

52662

42

53783

105

09.12.14

09.12.14

8

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Page 2

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Parent Item: D350-591-214RevA



Parent Item Name: Heli-Access-Step, Short RH

Start Date: 02/12/2009

Required Date: 16/12/2009

Comments: IPP Rev:D 06-06-27 Revised as per DSI9340 JLM
Ipp Rev E 09.11.23 added comment for D2732 EC

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MS20600-AD4W4		Purchased	No				Each	1,631.000	64.0000			
											09-12-14	
Rivets												

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
ST	1631	
110731	215	
111359	46	
111477	74	
112314	1272	
112385	24	

D2622-120CRevC1 Manufactured No



Step Extrusion

110 Each 89.3200 2.0000



09-12-08

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
WA	89.32	
48612	6.62	
52026	82.7	
39316		



1.5
5

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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December 2, 2009 11:41:26 AM

Work Order ID: 54193

Parent Item: D350-591-214RevA

Parent Item Name: Heli-Access-Step, Short RH

Comments: IPP Rev:D 06-05-27 Revised as per DSI9340 JLM
Ipp Rev E 09.11.23 added comment for D2732 EC

Start Date: 02/12/2009

Required Date: 16/12/2009

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3063-1RevA		Manufactured	No			130	Each	33.0000	4.0000		12.09.09	
Support												

Warehouse	Location	Loc Qty	Loc Code
Main Warehouse	ST	33	
	51237	33	
D3067-1RevA	Manufactured	No	
End Plate			

Warehouse	Location	Loc Qty	Loc Code
Main Warehouse	ST	169	
	53451	49	
	53784	120	
D3067-1RevA	Manufactured	No	
End Plate			

Warehouse	Location	Loc Qty	Loc Code
Main Warehouse	ST	169	
	53451	49	
	53784	120	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Ipp Rev E 09.11.23 added comment for D2732 EC

Start Date: 02/12/2009

Required Date: 16/12/2009

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN3-35A		Purchased	No			270	Each	341.0000	8.0000			
<div>  </div>												
Bolt												

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

341

106993

12

110467

1

112314

328

270

Each

550.0000

24.0000

AN4-11A

Purchased

No

Bolt

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

550

110382

550

270

Each

36.0000

16.0000

AN4-13A

Purchased

No

Bolt

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

36

113226

36

17406

0

51764

0

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Ipp Rev E 09.11.23 added comment for D2732 EC

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN4-16A		Purchased	No			270	Each	172.0000	16.0000			

Ex Bolt

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

172

112969

172

AN960JD10

Purchased

No

270

Each

2,043.000

16.0000

Washer

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

2043

105442

8

109059

2

109840

23

110985

202

111279

5

111668

64

112314

725

112369

14

113149

1000

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Ipp Rev E 09.11.23 added comment for D2732: EC

Start Date: 02/12/2009

Required Date: 16/12/2009

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN960JD416		Purchased	No			270	Each	2,411.000	48.0000			

S12



Washer

NA51149004632

NA51149004633 per DSI 10178
4/12/17

Warehouse	Loc Qty	Loc Code
<u>Location</u>		
Main Warehouse		
ST	2411	
108161	329	
110523	340	
111279	101	
111916	482	
112314	1159	
16941	0	



M110914 9/12/17 SP

D2230-1RevG

Manufactured No

270 Each 97.0000 8.0000

S74



Lug

Warehouse	Loc Qty	Loc Code
<u>Location</u>		
Main Warehouse		
FG	97	
51566	97	



B53782 9/12/17 SP

W/O:		WORK ORDER CHANGES					
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Comments: IPP Rev:D 06-06-27 Revised as per DSI9340 JLM
Ipp Rev E 09.11.23 added comment for D2732 EC

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2230-3RevG		Manufactured	No			270	Each	9.0000	8.0000			

S-4 Lug



153450 9/12/17 SP

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST 3

51568 3

Main Warehouse

ST176 6

51428 6

D2732RevB1

Manufactured No

270 f

180.6200 4.0000

S-4 Rubber Extrusion



9/12/17 SP 4

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST 180.62

38509 20.62

43118 160

Cut 3.00" long, qty 4

67 MEASGOLD 9/12/17

4x

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Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2856-400RevA		Manufactured	No			270	f	325.1821	2.4000			
<div>  </div>												
<div>  </div>												
<div>  </div>												

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
ST403	325.1820842	
50593	141.312084	
52563	183.87	

cut 7.20" long, qty 1
MS21042L3

Purchased No

Nut

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
ST	2809	
110844	32	
111274	27	
111668	258	
112314	1992	
112385	500	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Page 9

December 2, 2009 11:41:26 AM

Work Order ID: 54193



Parent Item: D350-591-214RevA



Parent Item Name: Heli-Access-Step, Short RH

Start Date: 02/12/2009

Required Date: 16/12/2009

Comments: IPP Rev:D 06-06-27 Revised as per DSI9340 JLM
Ipp Rev E 09.11.23 added comment for D2732 EC

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Repiacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MS21042L4		Purchased	No			270	Each	4,301.000	24.0000			

64 Nut



9/12/10 SD 4x

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

4301

110507

184

111827

4117

15924

0

24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



RELEASED
02.09.20

DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3078	REV. A SHEET 1 OF 2
DATE 02.09.11		TITLE STEP ASSEMBLY, HI SHORT SCALE NTS	
A	02.09.11	NEW ISSUE	

SHOW
RETURN
ENGINE
UNCONTROLLED
SUBJECT TO
WITH
WORK
NO. **541193**

Part No.	Description	QTY -041	QTY -042
D3078-041	Step Assembly, High Short (LH)	X	
D3078-042	Step Assembly, High Short (RH)		X
D2622-60	STEP EXTRUSION	1	1
D3063-1	SUPPORT	1	1
D3065-041	LEG ASSEMBLY	1	1
D3066-1	SPACER	2	2
D3067-1	END PLATE	2	2
MS20600AD4W4	RIVET	16	16

GENERAL NOTES:

- 1) -041 SHOWN, FOR -042 INSTALL D3063-1 SUPPORT OPPOSITE SIDE
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.

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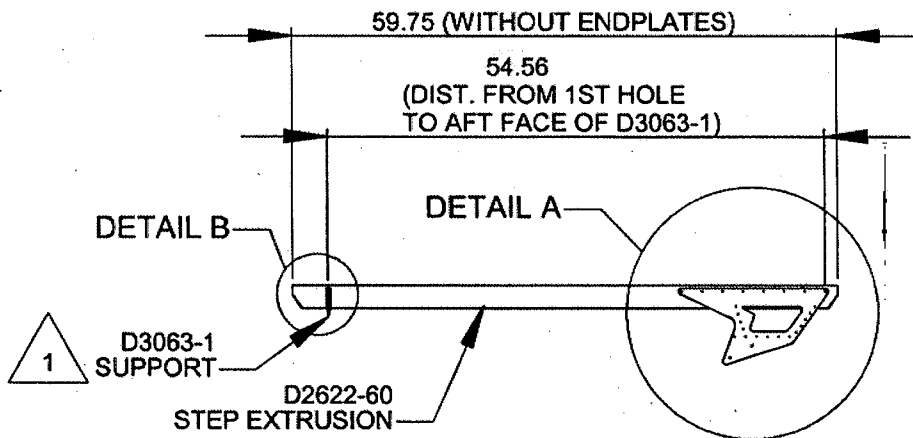
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DART

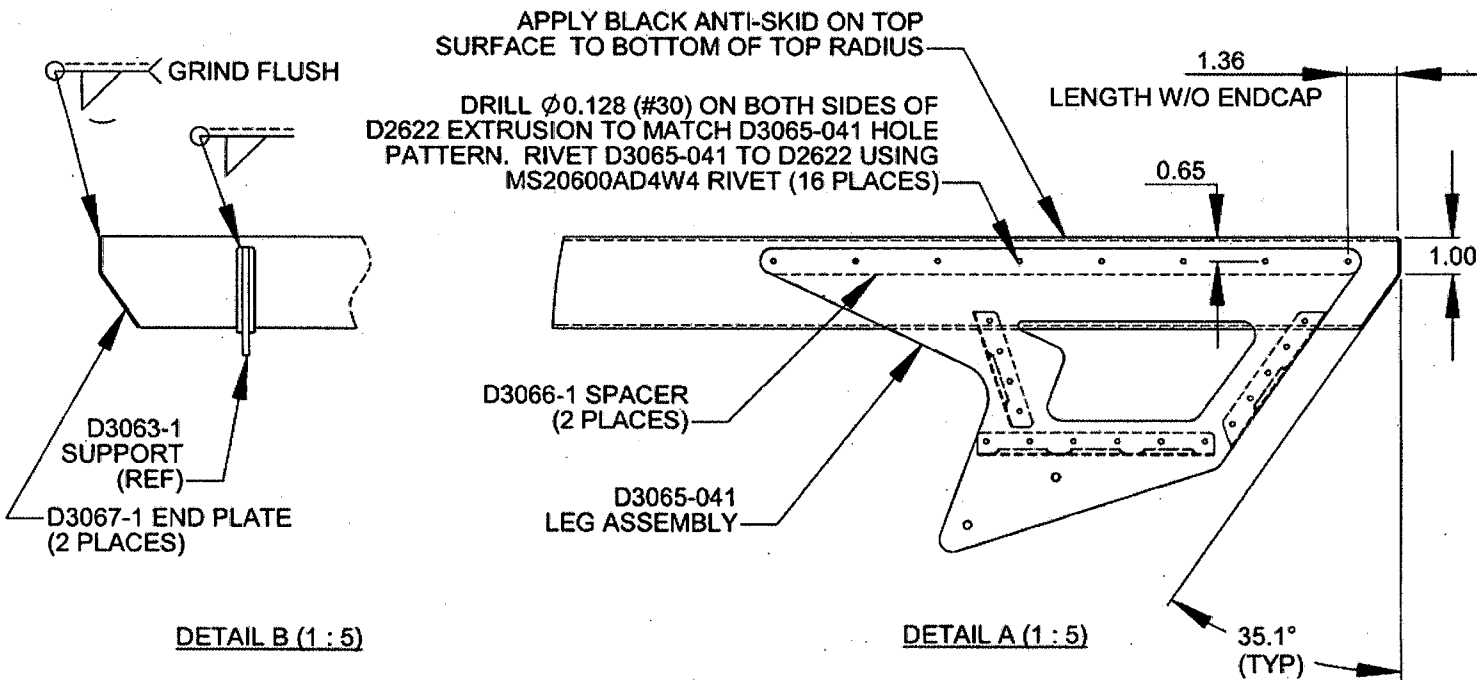


DESIGN	W	DRAWN BY	W	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	W	APPROVED	W	DRAWING NO. D3078
DATE	02.09.11	TITLE	STEP ASSEMBLY, HI SHORT	REV. A SHEET 2 OF 2
		SCALE	1:20	

RELEASED
02.09.2004



DOE



59.75
54.56
58.29